

MP208 pen



Needed:

Mandrel A; drill "V"; bushing 69A

Preparing the blank

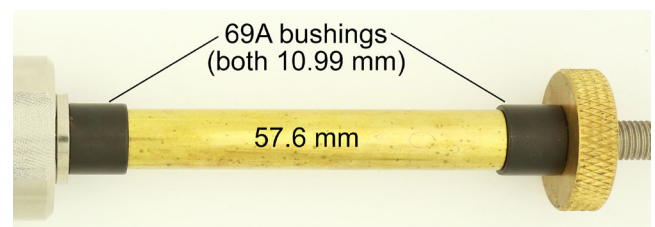
1. Cut the blank approximately $\frac{1}{4}$ " longer than the length of the brass tube.
2. Drill the blank through the centre, lengthwise, with the "V" drill bit.
3. Polish the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax– to keep the glue from getting into the tube. *Glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in the glue. Insert the tube with a twisting motion until it is equidistant between both ends of the blank.
6. Set aside until the glue has had time to reach its maximum strength.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends. Using a barrel trimmer of the proper size, square off the ends of the blanks until you can see bright brass tube. STOP at

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this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

Turning the blank



1. Assemble the blank on the mandrel using the 69A bushings, following the diagram above.
2. Bring the tail stock up and secure. Lightly tighten the mandrel and secure.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. Sand the surface in progressive steps until you get to 400 or 600 grit. For a smooth finish, sand with Micro Mesh to 12,000 grit. Use a finish of your choice.
5. Remove the blank from the mandrel.

Assembling the pen

1. Press the center band into one end of the cap tube.
2. Slide the clip onto the finial cap. Press the assembly into the clip bushing.
3. Press the completed assembly into the other end of the cap tube.
4. Lay the cap aside.
5. Press the threaded nib coupler into one end of the blank.
6. Press the threaded body coupler into the other end of the blank.
7. Press the finial into the finial insert.
8. Thread the finial assembly into one end of the threaded coupler.
9. Place the spring on the end of the refill and slide the refill into the end of the pen.
10. Thread the nib into the other threaded coupler.

